

FAASA - 205 basket

Dart Aerospace Ltd.

Date:
User:Tuesday, 26/02/2008 1:40:15 PM
Linda Lacelle

Process Sheet

SP1.7
08/03/04SP1.7
08/03/0512
14

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HOOP
 Job Number : 37626 - 23
 Estimate Number : 13140
 P.O. Number :
 This Issue : 26/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 37626
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-01-30 new issue DD verified by:EC
 Est Rev:B 08-02-26 change to rev.A verified by:

Part Number : D37251
 Drawing Number : D3725 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 07/03/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304B0625X3000 304 BAR .625 X 3.00



7



Comment: Qty.: 0.4375 f(s)/Unit Total: 4.3754 f(s)

304 stainless steel bar .625"x 3.00"

(M304B0625X3000)

Batch: 07078

IB 8-2-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3725

Dwg Rev: A

Prog Rev: A

IB 8-2-27

(16)

DEBURR IB 8-2-27

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/03/03 (15)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Make chamfer by hand as per dwg D3725

2- Deburr

FF 08-03-07

Date: Tuesday, 26/02/2008 1:40:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOOP

Job Number: 37626

Part Number: D37251

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/07/06 (11)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Karl L.

AS 08/03/07 x11

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11 08/03/06

Job Completion



mi 2008/3/07

(11)

(PD) 7

Date: Tuesday, 2/26/2008 8:01:18 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HOOP |
| Job Number : 37626 | |
| Estimate Number : 13140 | |
| P.O. Number : | Part Number : D37251 |
| This Issue : 2/26/2008 S.O. No. : | Drawing Number : D3725 <i>Rev A</i> |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : <i>Rev A</i> |
| Previous Run : 37127 | Material : |
| Written By : | Due Date : 3/7/2008 Qty: 10 Um: Each |
| Checked & Approved By : | |
| Comment : Est Rev:A 08-01-30 new issue DD verified by:EC | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304B0750X3000

*M304B0625x3000**304 Bar .625" x 3.00*

10/08/02/26
 Comment: Qty.: 0.4375 f(s)/Unit Total : 4.3754 f(s)

304 stainless steel bar .750" x 3.00"

(M304B0750X3000)

Batch: _____

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3725

Dwg Rev: _____

Prog Rev: _____

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



10/08/02/26
 Comment: CONVENTIONAL MILLING MACHINE

1- Face to finish size as per dwg D3725

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3725-1 PAR #: N/A Fault Category: Prod/Inspection NCR: Yes ☒ No ☐ DQA: D Date: 08/03/07
 QA: N/C Closed: JA Date: 08/03/10

| NCR: <u>37626</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|---------|---|-----------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/03/03 | # 20 | one parts seam hole was elongated RC Hummer/machine mal/fuction | <u>Postul</u> | Scrap and Defect No Repl/see Qty (1) | <u>P 2-3-3</u> | <u>08/03/03</u> | <u>Postul</u> | <u>08/03/03</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:01:18 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOOP

Job Number: 37626

Part Number: D37251

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Make chamfer by hand as per dwg D3725

2- Deburr

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



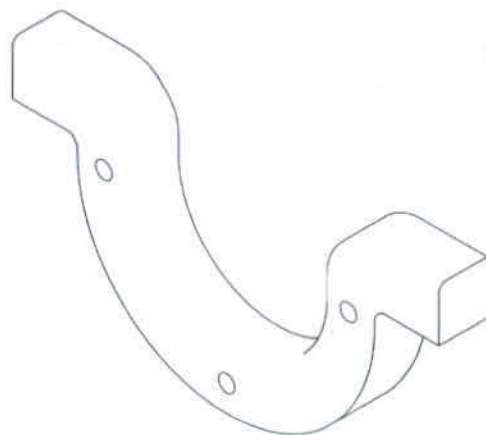
Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3725-1 HOOP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 37626

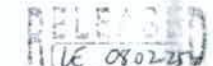
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
(REF. DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

RELEASED
 16 08-02-25

| | | | |
|------------|-----------------|--|--------------|
| A | INITIAL RELEASE | AJS | 08.01.28 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | DRAWING NO. D3725 TITLE HOOP DATE 08.01.28 | |
| | | REV. A | SHEET 1 OF 2 |
| | | SCALE | NTS |

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| | |
|---|--------------|
| DART AEROSPACE LTD | |
| HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3725 | REV. A |
| | SHEET 2 OF 2 |
| TITLE HOOP | SCALE NTS |
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